

Date: Friday, 21/11/2008 2:31:22 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 43703
 Estimate Number : 10368
 P.O. Number :
 This Issue : 21/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D30481
 Drawing Number : D3048 REV. A2
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : A2
 Previous Run : 36251 Material :
 Due Date : 25/11/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: A 02/11/19 New issue KJ/RF
 Est Rev:B Now on Waterjet 06-10-15 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 3.6312 sf(s)/Unit Total : 7.2624 sf(s)

2024-T3 .063 sheet

Material: 2024-T3 (QQ-A-250/4) 0.063 thick

(M2024T3S.063)

Batch: 108415 HB 8-11-24

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3048

Dwg Rev: A2

Prog Rev: A2

HB 8-11-24

②

2-Deburr if necessary

HB 8-11-24

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-11-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Soulub 4 ②

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form on CNC Brake per Dwg D3048

SB 08/11/25 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 21/11/2008 2:31:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43703

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L *08/11/25* *25*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/25 *42*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST152*

AS *08/11/25* *42*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 *42*

Job Completion



MF *08-11-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43703
Description: DOUBLER	Part Number:	D3048-1
Inspection Dwg: D3048-1, Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x

x

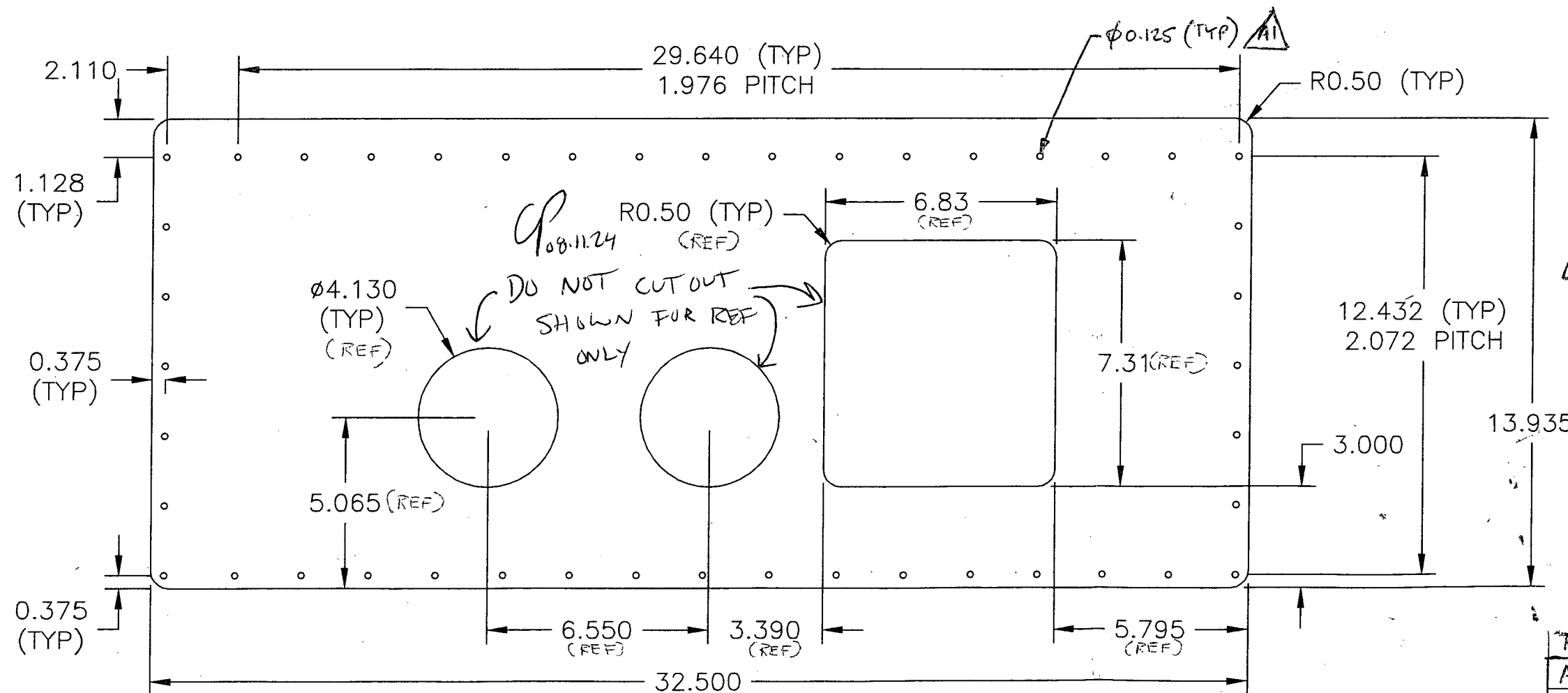
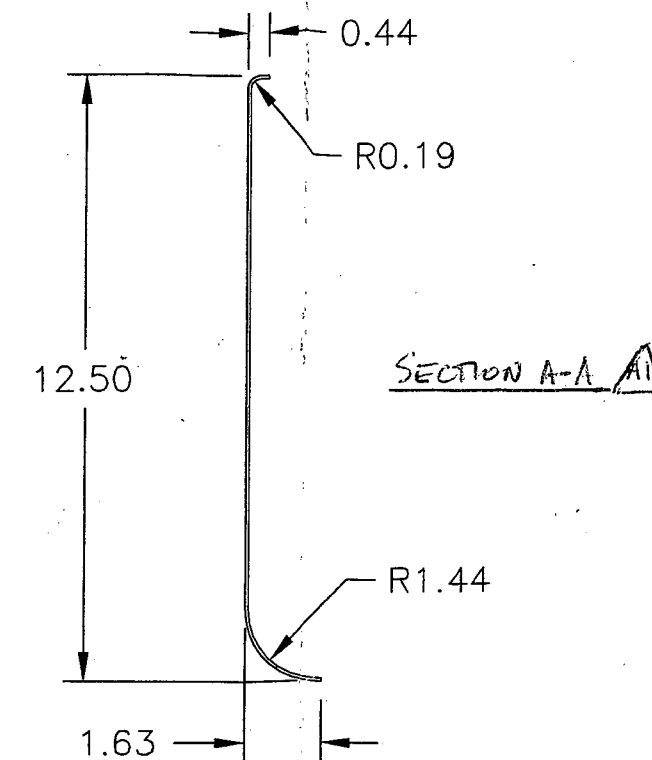
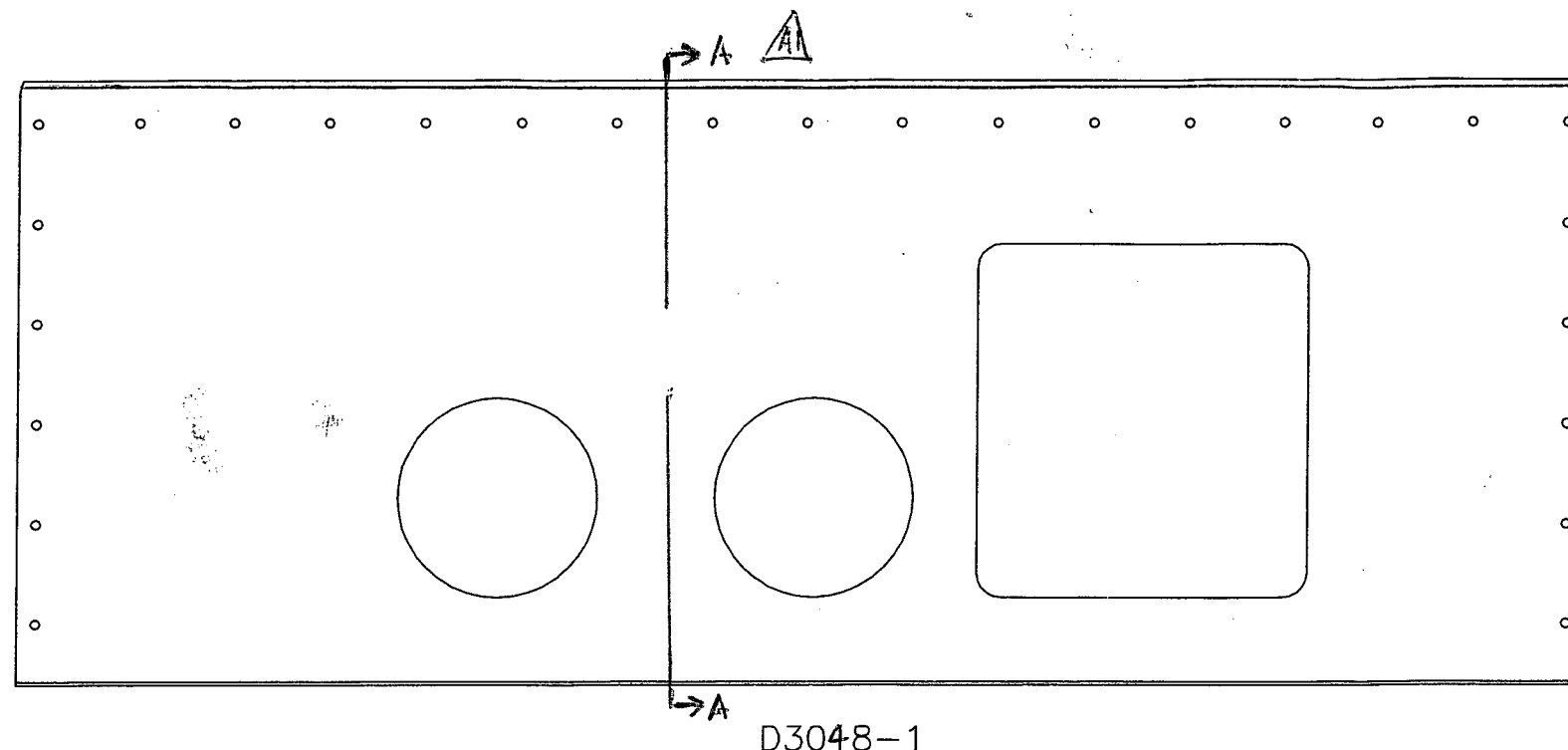
[illegible]

Measured by:	H3
Date:	8-11-24

Audited by:	S
Date:	08/11/2017

Prototype Approval:	<i>[Signature]</i>
Date:	<i>1/17</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



MATERIAL: 2024-T3 (QQ-A-250/4)
 0.063 THICK
 FINISH: ACID ETCH, ALODINE PER DART
 QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

A2 CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,
 DO NOT CUT.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 43203



A2	04.11.10	REMOVE CUT-OUTS
A1	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO. D3048
		TITLE DOUBLER
		REV. A
		SHEET 1 OF 1
		SCALE 1:4

D3048-1 FLAT PATTERN

RELEASED
 01.09.27

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